

Work Order ID 162605***162605***

Page 1

Monday, June 05, 2017 9:43:22 AM

Item ID: D5321-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Ring

Stop ***NS2***

Start Date: 6/20/2017 Start Qty: 30.00

Required Date: 6/20/2017 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: **DAS**

Date:

Tooling:

Date:

Run Start ***NR1***QC: **21**

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5321

B

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: **36660**

Possible supplier: ANCRA

Supplier P/N: 48557-11

C of C is required.

0.00

15
30

JUN 12 2017

DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

15x 8017-7-19.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 162605

Monday, June 05, 2017 9:43:22 AM

162605

Page 2

Item ID: D5321-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ring
Start Date: 6/20/2017 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 6/20/2017 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				15			DAS 38 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>SH/57</u> Memo	0.00 0.00				15			DAS 6 9-89
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							17/7/20 2017

DAS
21
9-89

JUL 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER :									

Picklist Print

Monday, June 05, 2017 9:43:20 AM

Page 1

Work Order ID: 162605

162605

Parent Item: D5321-3

D5321-3

Parent Item Name: Ring

Start Date: 6/20/2017

Required Date: 6/20/2017

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 15.10.13 NEW ISSUE DD VERF:JLM IPP
REV:B 16.03.28 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

48557-11

Purchased

No

100

Each

0.0000

1

48557-11

**

Ring

15x 8017-7-19

DQA: _____ Date: _____



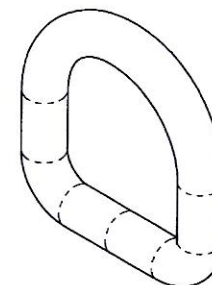
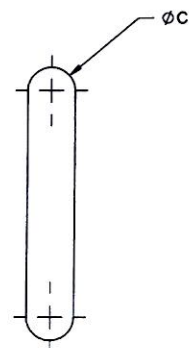
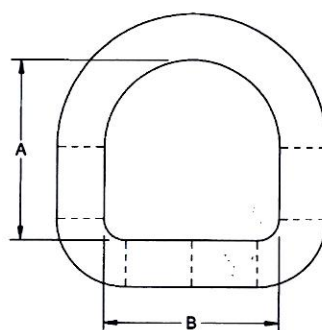
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162605 MCL
170607

D5321-X RING

PART NUMBER	VENDOR	VENDOR P/N	BREAK STRENGTH	WORKING LOAD LIMIT	WEIGHT	DIM 'A'	DIM 'B'	DIM 'C'	MATERIAL
D5321-1	U.S.C.C.	MR15	6,000 lbs	2,000 lbs	0.22 lbs	1.50	1.45	0.39	ZINC PLATED STEEL
D5321-3	ANCRA	48557-11	5,000 lbs	1,666 lbs	0.09 lbs	1.50	1.50	0.25	CAD PLATED STEEL
D5321-5	MCMaster-CARR	9372T21	600 lbs	200 lbs	0.05 lbs	0.81	1.06	0.22	NICKEL PLATED STEEL

B

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: SEE TABLE

B	ADD D5321-5	DB	16.02.08
A	NEW RELEASE	DB	15.09.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	AK		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DSS		
DATE	16.02.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5321** REV. B
SHEET 1 OF 1
TITLE **RING** SCALE NTS

COPYRIGHT © 2015 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
2016-03-23
EN 16-548

APPROVED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36660**

Purchase Order Date 6/12/2017 9:16:56 AM

PO Print Date 7/11/2017

Page Number 1 of 1

Order From :
ANCRA INTERNATIONAL, LLC
27382 NETWORK PLACE
CHICAGO, IL 60673-1273
US

VU-ANC001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	48557-11	Ring	7/17/2017 Yes 7/17/2017	FN	15.00 Each	\$6.95	\$104.25
	AS PER DWG D5321 REV. B B162605						
						Line Total:	\$104.25
2	71401-45	PROCUREMENT QUALITY CLAUSES	7/14/2017 No 7/14/2017		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS					Line Total:	\$0.00
						PO Total:	\$104.25

CZ
Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 3

Change Date: 7/11/2017



ANCRA
INTERNATIONAL LLC

875 West 8th Street
Azusa, California 91702

Phone: (310) 973-5000 • FAX: (310) 973-1138

Shipping List Number 805001-1

Customer Order		Order Date	Page
P036660		07-11-17	1

Ship To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Bill To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Via: FedEx Ground
Ship from: W ANCRA WEST AZUSA

Contact : CHANTAL LAVOIE
Freight Terms : COL

Order Entered By: DJohnson

Item Number	Description	Sell UM	Sell QtyShip...	To Stk UM	Bin Loc	Stock Qty To Ship	Shipped Qty/UM
1 48557-11	Facility W :D-RING- 1 1/2" Cust PN: 71900-90 Rev. Level: G ** Line Item Comments ** MARK LOT NUMBER: CO21260P ** Special Instructions ** USE FEDEX GROUND ACCT 151793240 Allocated: 07-12-17 Printed: 07-12-17 07:27:46	EA	15	EA	4R05	15	15

SOP-719



ANCRA
INTERNATIONAL LLC

875 West 8th Street
Azusa, California 91702

Phone: (310) 973-5000 • FAX: (310) 973-1138

Shipping List Number 805001-1

Customer Order		Order Date	Page
P036660		07-11-17	2

Ship To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Bill To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Via: FedEx Ground
Ship from: W ANCRA WEST AZUSA

Contact : CHANTAL LAVOIE
Freight Terms : COL

rd Ent By: DJohnson

Item o Number	Description	Sell UM	Sell QtyShip...	To Stk UM	Bin Loc	Stock Qty To Ship	Shipped Qty/UM
------------------	-------------	------------	--------------------------	--------------	------------	----------------------	-------------------

CERTIFICATE OF CONFORMANCE

WE HEREBY CERTIFY THAT THE ABOVE STATED PART NUMBERS REPRESENTED ARE NEW AND HAVE BEEN MANUFACTURED AND INSPECTED IN ACCORDANCE WITH OUR QUALITY ASSURANCE MANUAL, ALL RELEVANT DRAWINGS, SPECIFICATIONS, PURCHASE ORDER REQUIREMENTS, AND LEGIBLY MARKED IN ACCORDANCE WITH FAR 45.15, IF APPLICABLE.

ALL CHEMICAL, PHYSICAL OR FUNCTIONAL TEST REPORTS RELEVANT TO THE CERTIFICATION OF CONFORMANCE ARE ON FILE IN OUR QUALITY ASSURANCE OFFICE.

INSPECTOR _____

DATE: 7/12/17

Shortage Claim Policy

Ancra customer is responsible for inspecting incoming shipments. Ancra must be notified within fifteen(15) days of receipt of shipment if material is not as ordered, quantity is either surplus or short, or if any damage has occurred in shipment. No claims submitted to Ancra will be accepted after fifteen(15) days of receipt.

Pay
Terms

NET 30